

Date: Thursday, 18/12/2008 12:51:05 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 44158	
Estimate Number : 10314	
P.O. Number :	Part Number : D265613
This Issue : 18/12/2008 S.O. No. :	Drawing Number : D2656 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : 18/12/2008 Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 42772	Material :
Written By :	Due Date : 10/01/2009 Qty : 15 Um : Each
Checked & Approved By : <u>JUD 08.12.19</u>	
Comment : Est: F 02.10.25 Re-format KJ/RF Est Rev:G Now on Waterjet 06-07-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025 SHEET
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Comment: Qty.: 0.8500 sf(s)/Unit Total: 12.7500 sf(s)
 1010/1025/A21/6aA SHEET **110368** **1B 9-1-8**

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2656
 Dwg Rev: D
 Prog Rev: D

1B 9-1-8**(15)**

2-Deburr if necessary

1B 9-1-8

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**1B 9-1-8****Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK**S 09/01/09 (15)**

5.0	BRAKE NC	NC BRAKE
-----	----------	----------

**Comment:** NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326
 2-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13

SB 09/01/12 (15)
SB 09/01/13 (15)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 18/12/2008 12:51:06 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 44158

Part Number: D265613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/01/13 (15)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

7:15

OVEN TEMPERATURE:

320°

FINISH TIME:

7:45

FL 09/01/14

(15)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-14

(15)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FR-20

FL 09/01/14

(15)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/15 (15)

Job Completion



JUD 09/01/14 (15)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44158
Description: Wearshoe		Part Number: D2656-13
Inspection Dwg: D2656	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	X			
5.650	+/-0.010	5.648	X			
9.150	+/-0.010	9.145	X			
0.300	+/-0.010	.303	X			
0.300	+/-0.010	.302	*			
.040	+/- .010	.040	X			

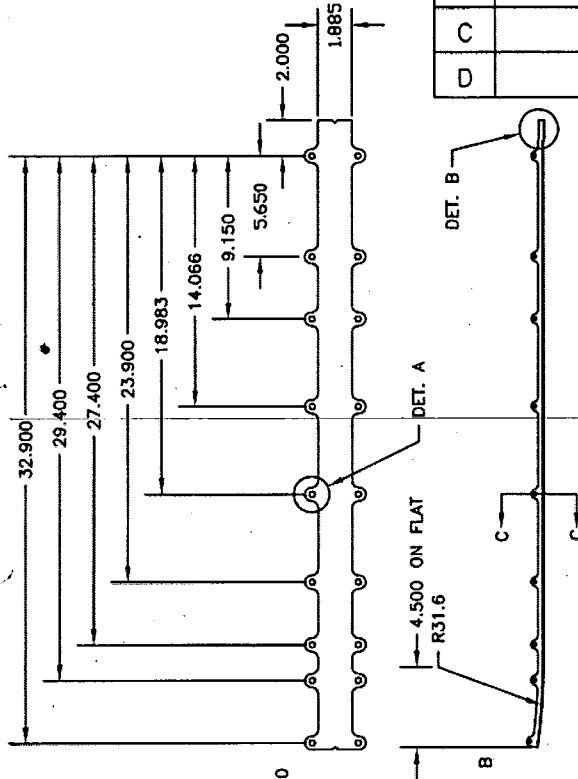
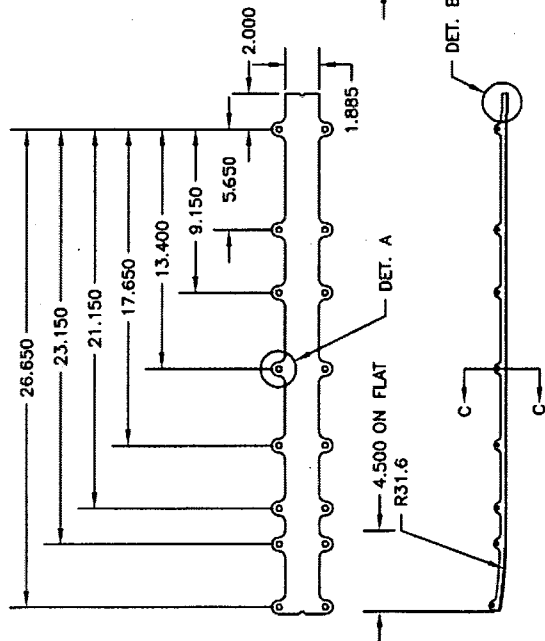
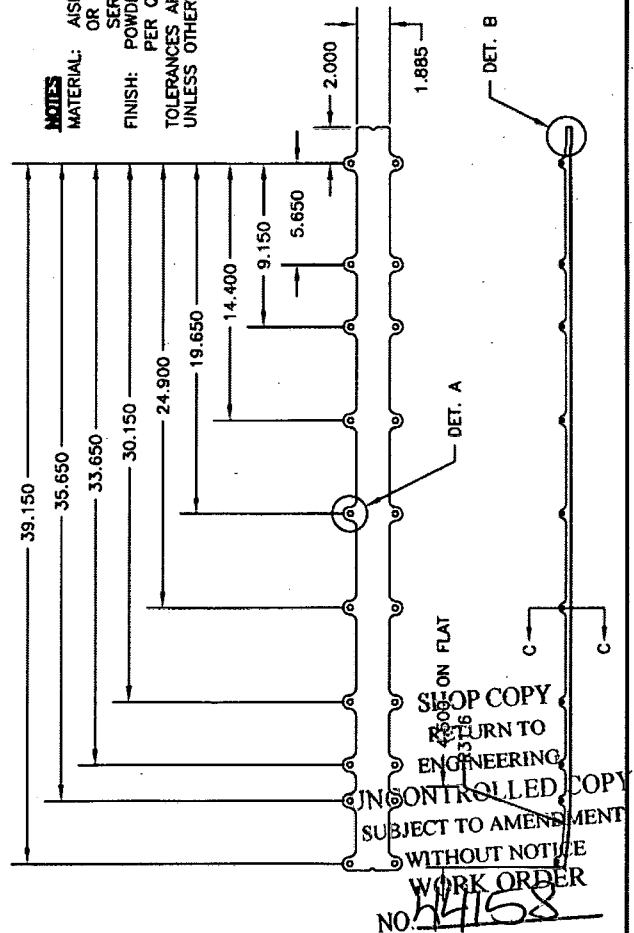
Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-1-8	Date: 09/01/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.05	New Issue	KJ/JLM	BE

[Handwritten signature]

DART

DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2656	REV. D SHEET 1 OF 4
DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10
A	97:03:25	NEW ISSUE	
B	97:06:02	CHANGED TABS	
C	97:06:26	R31.6 WAS R19.5	
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT	

D2656-13**D2656-11****D2656-15**

NOTES:
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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05.09.08 [Signature]

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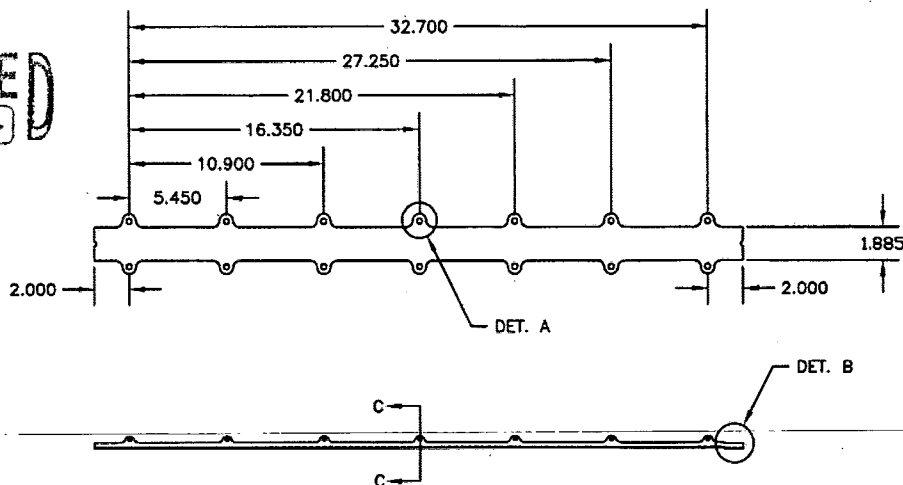
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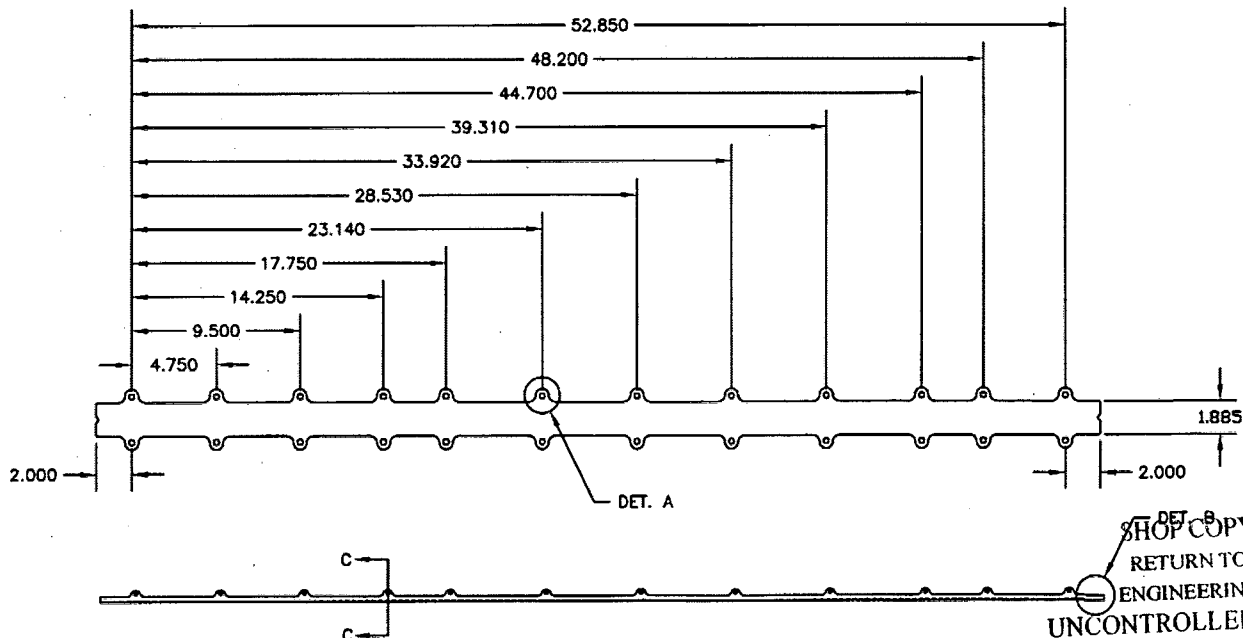
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D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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NO. 44158

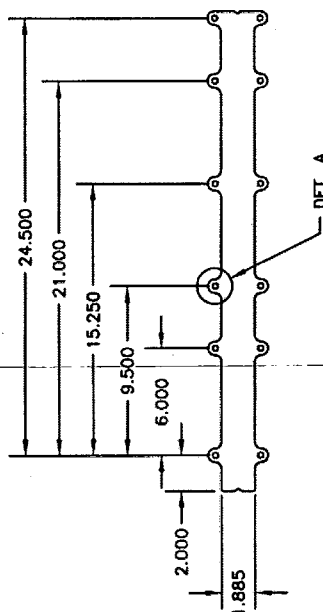
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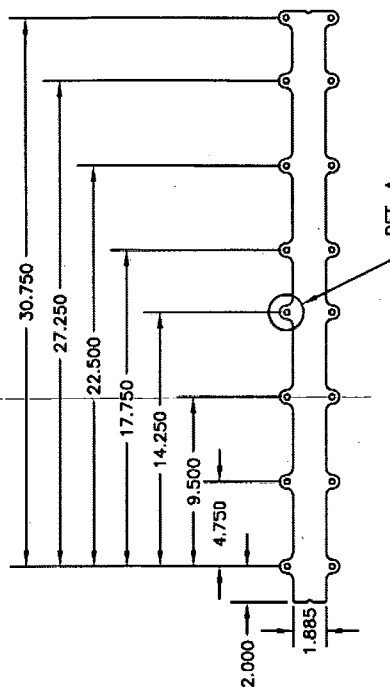


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D2656-33

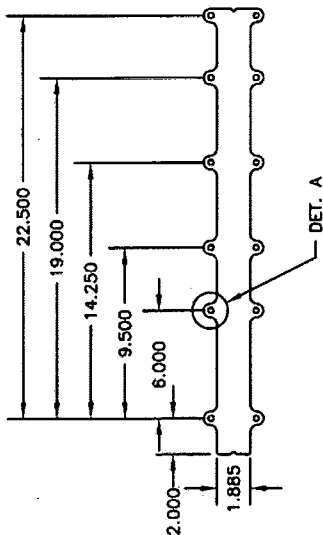


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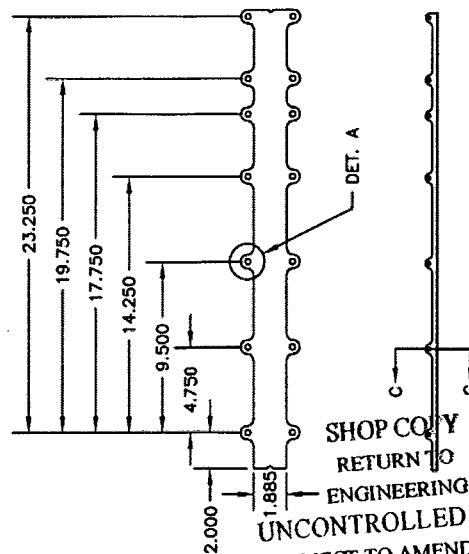


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MATERIAL: AISI 1010-1025 OR ASTM A36/A36/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
FINISH: SERIES STEEL, 20 GAUGE (0.040 THICK)
POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

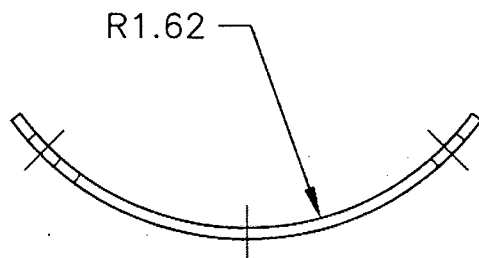
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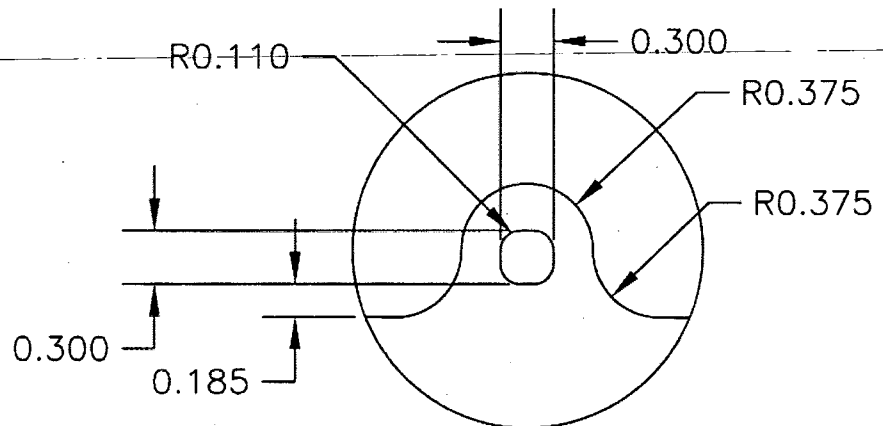
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

SECTION C-C

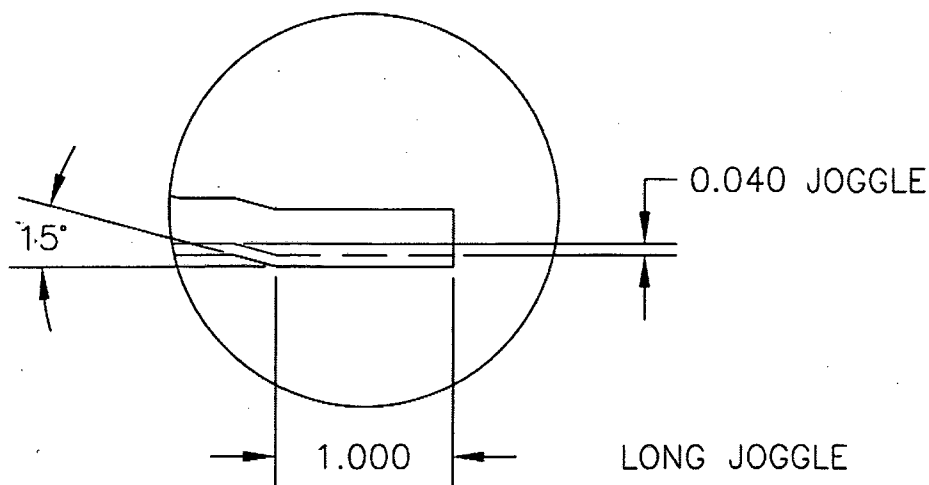


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DETAIL A



DETAIL B



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WORK ORDER

NO. 44158